

5/28/2018

LAKKE FAB

[Dart Hawkesbury] Job Sheet - David, Logan



Dart Aerospace Ltd.
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K6A 1K7
Canada

Tel (613) 632-5200

RBEM262V3000101-1

Job Sheet 178192



Part No: RBEM262V3000101-1

Job Qty: 6 ea

Part Name: Frame Weldment



Part Weight: 0 lbs

Status: At Planning

Priority: Medium

Job Created: 5/28/18

Job Tracking No:

Due Date: 7/9/18

Created By: Logan David

Type: SOLD

Description:

Note: DWG RBEM262V3000101 Rev. 1 IPP Rev. A 18.05.14 new issue DP Verify DD

Ship Via:

Bill of Materials

Job Routing

Op No	Operation	Qty	Start Date	Due Date	Standard		Workcenter/Supplier		Sign-off
					Setup hrs	Run Hrs	Workcenter / Supplier	Lead Time	
90	Start up Operation	6 Ea	7/9/18	7/9/18	0.00	0.00	Start Up Small Fab-2		12
110	Large Fab	6 pcs	7/9/18	7/9/18	0.00	6.00	Large Fab 3		12
115	QC	6 pcs	7/9/18	7/9/18	0.00	0.00	QC9		PD 15-08-03
120	QC	6 pcs	7/9/18	7/9/18	0.00	0.00	QC5		PD 18-03-23
130	Powdercoat	6 pcs	7/9/18	7/9/18	0.00	0.60	Powdercoat13		001 8-26-09
140	QC	6 pcs	7/9/18	7/9/18	0.00	0.00	QC3		AUG 23 2018
180	Packaging	6 pcs	7/9/18	7/9/18	0.00	0.00	Packaging3		MUL 033 9-09
190	QC21-SA	6 Ea	7/9/18	7/9/18	0.00	0.00	QC21		0-20 21 AUG 24 2018

Part Op 110 - 1-Cut RBEM262V3000101-3/-5/-7/-9/-11/13. 2-Drill hole in -5. 3-Weld as per DWG.

Descriptions: 130 - ***Note***No Powder Coat in threaded holes. START TIME: 10:45 OVEN TEMPERATURE: 320°

FINISH TIME: 11:10

140 - Ink stamp tool number

TEMPS: (0.17) BK 18-8-22

START: 8:25 O.V.T: 320° FINISH: 3:55

Job BOM

Part / Item	Component Name	Quantity	Operation	Container
RBEM262V3000101-15	Gusset	12 Ea (2 ea)	90-Start up Operation	5093519
RBEM262V3000101-17	Main Plate	6 Ea (1 ea)	90-Start up Operation	5098402
M1018A2.500W.250	M1018A2.500W.250	6.6900 ft (1.115 ea)	110-Large Fab	5009407
M1018TS0.750W.070	M1018TS0.750W.070 order .065"	13.2000 ft (2.2 ea)	110-Large Fab	5088869

Job Allocations

Operation	Component Part	Required	Inventory	Allocated
90-Start up Operation	RBEM262V3000101-15	12	0	0
	RBEM262V3000101-17	6	0	0
110-Large Fab	M1018A2.500W.250	7	0	0
	M1018TS0.750W.070	13	0	0

Part Specifications

Specifications could not be found.

Plex 5/28/18 3:13 PM dart.logan.david



Container No: S098512



Part: RBEM262V3000101-1

Job No: 178192

Serial No/Batch: S098512

Revision: 1

Inspector:

Exp Date:

Instructions:

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RBEM262V3000101-1

S098512

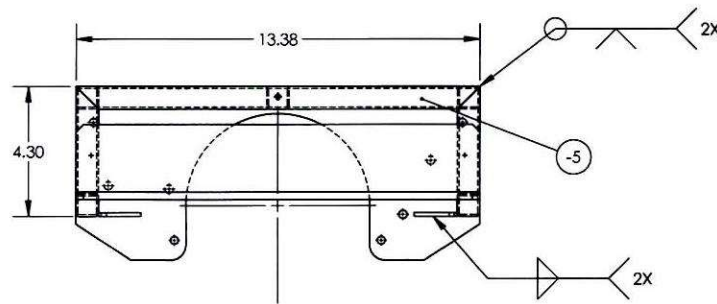
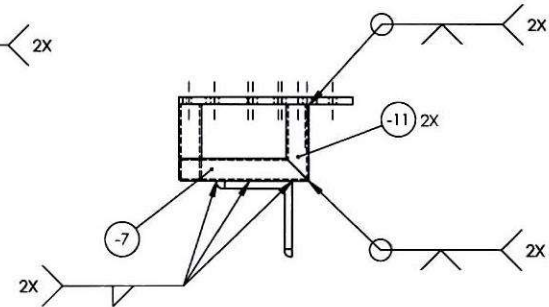
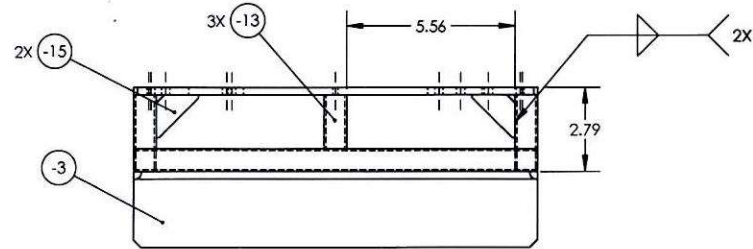
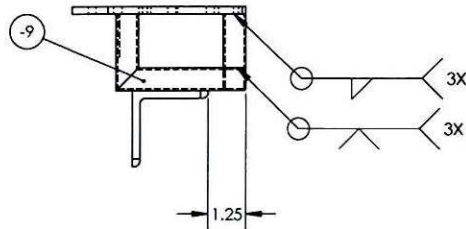
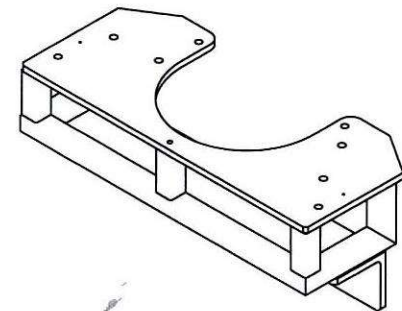
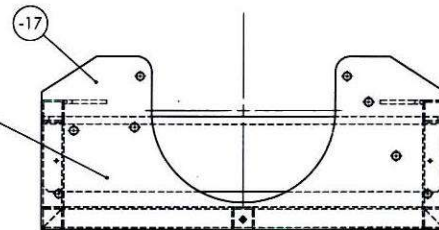
Date: 08/02/18

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REVISIONS			
REV	ECR	DESCRIPTION	DATE INITIAL APPROVED

INK STAMP T/N, S/N,
"MADE IN USA"



FRAME WELDMENT

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WITHOUT NOTICE
WORK ORDER
NO. 178192

20180712

NOTE:
NO POWDER COAT IN THREADED HOLES.

DART AEROSPACE	
TITLE EXTINGUISHING BOTTLE SUPPORT	
DWG NO. RBEM262V3000101-1	REV 1
MATL ALUMINUM 6061-T6	UNLESS OTHERWISE SPECIFIED DIMENSIONS ARE IN INCHES
FINISH POWDER COAT YELLOW	.XXX ± .010 FRACTIONS ± 1/8
SPEC FED #13538	.XX ± .03 ANGLES ± 1°
DRAWN BY: DUERFELDT	.X ± 1 SURFACES ± 125
CHECKED: CLOUGH	1. BREAK ALL SHARP EDGES
QAPP APPR: ANDERSON	2. DIMENSIONAL LIMITS APPLY AFTER PLATING
QA APPR: LINDSAY	3. INTERPRET DIM AND TOL PER ASME Y14.5M-2009
APPROVED: GILBERT	USED ON MODEL H175
SCALE 1:4	DATE 6/20/2016
SHEET 2 OF 15	